

Date: Monday, 11/21/2005 11:58:03 AM  
User: Linda Lacelle

## **Process Sheet**

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACER BUSHING
Job Number	: 24874		
Estimate Number	: 10826		
P.O. Number	: N/A	Part Number	: D23273
This Issue	: 11/21/2005 S.O. No. : N/A	Drawing Number	: D2327 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: C
Previous Run	: N/A	Material	: N/A
Written By	: See comment below	Due Date	: 12/15/2005
Checked & Approved By	: See comment below	Qty:	50
Comment	: Est. F 05.11.02 Removed 303 SS KJ/EC	Um:	Each
<b>Additional Product</b>			
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	M304RO750	Inventory	
		Comment: Qty.: 0.1641 f(s)/Unit Total : 8.2058 f(s) Inventory 303 Material: AISI 304 Round Bar Ø0.375" (M304RO.375)	
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HARDINGE CNC LATHE SMALL Turn per Folio FA232 and Dwg D2327 Deburr	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 432	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 05/11/24  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER BUSHING

Job Number: 24874

Part Number: D23273

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL

Inspection Level 21

*545 05/11/24 (55)*



*(55) 05/11/24 (55)*

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

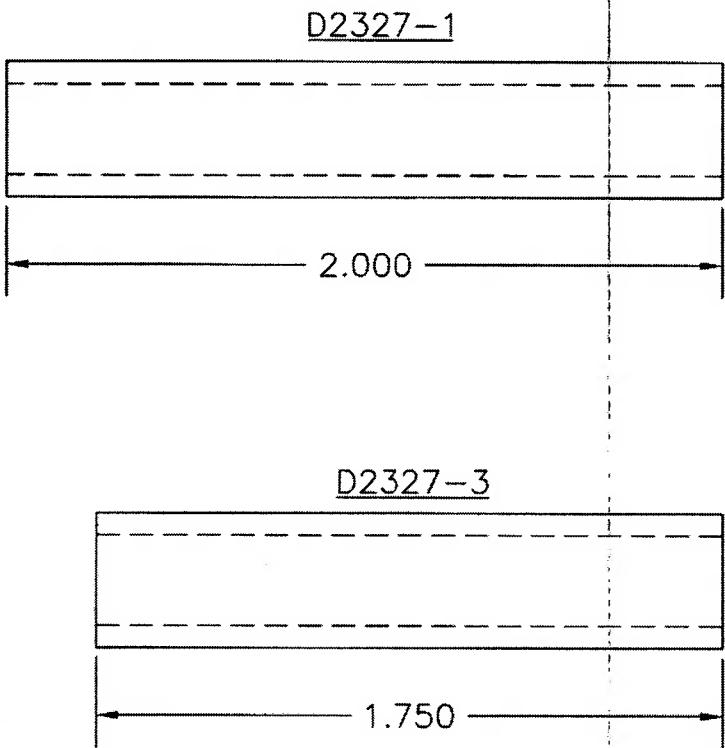
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

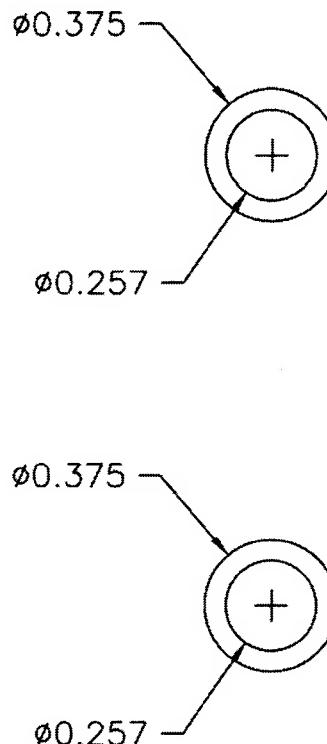
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NOTE:

- 1) MATERIAL:  $\varnothing 0.375$  AISI 303 ROUND BAR (REF DART SPEC. M303R0.375) OR  $\varnothing 0.375$  AISI 304/316 SS 0.065 WALL SEAMLESS ROUND TUBING (REF. DART SPEC. M304TR0.375W.065)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010



**RELEASED**  
03.05.21 *[Signature]*

<b>DART</b>		<b>DART AEROSPACE LTD</b>
		HAWKESBURY, ONTARIO, CANADA
ISSUED	APPROVED	DRAWING NO. D2327
DATE 03.05.13	REV. C	SHEET 1 OF 1
A	<i>[Signature]</i>	TITLE SPACER BUSHING
B	<i>[Signature]</i>	SCALE 2:1
C	<i>[Signature]</i>	94.12.17 NEW ISSUE
		95.12.06 LENGTH CHANGE
		03.05.13 303 SS SPEC ADDED

DART AEROSPACE LTD	Work Order:	
Description: Spacer Bushing	Part Number:	D2327-3
Inspection Dwg: D2327 Rev: C		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<u>gml</u>	Audited by:	<u>J.L</u>	Prototype Approval:	N/A
Date:	05/11/23	Date:	05.11.23	Date:	

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	04.01.13	New Issue	KJ/RF	

0000000000

Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Nov 18, 2005  
09:21 am

Work Order No : 0024874  
Project Name : D2327-3 Department Code:  
Project For : WK550 Burden Flags : NNNNNNN  
Work Order Type : Main WO Status : Open  
Main WO Number : Invoice State : Not Invoiced  
House Part Number : D2327-3 Invoice Date :  
Description : Spacer Bushing Invoice Number :  
Manufactured : Yes Invoice Amount : 0.00  
Amount Req'd : 50  
Amount Done : 0 Order Entry No :  
Start Date : 11-18-05 OE Value : 0.00  
Est Finish Date : 12-15-05  
Act Finish Date : Est Margin : 0.000%  
Drawings Reqd : No Actual Margin : 0.000%  
Ok for Approval :  
Approval Rec'd : \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss)	0.00	0.00